

§ 381.68

9 CFR Ch. III (1–1–03 Edition)

MAXIMUM PRODUCTION LINE RATES—CHICKENS  
AND SQUABS—TRADITIONAL INSPECTION  
PROCEDURES

| Line configuration <sup>1</sup> | Number<br>of in-<br>spection<br>stations | Birds<br>per in-<br>spector<br>per<br>minute |
|---------------------------------|--|--|
| 6–1 .....                       | 1  | 25   |
| 12–1 .....                      | 2  | 23   |
| 12–2 .....                      | 2  | 21   |
| 18–1 .....                      | 3  | 19   |
| 18–2 .....                      | 3  | 19   |
| 18–3 .....                      | 3  | 18   |
| 24–1 .....                      | 4  | 16½  |
| 24–2 .....                      | 4  | 16   |
| 24–4 .....                      | 4  | 15½  |

<sup>1</sup> Birds are suspended on the slaughter line at 6-inch intervals. The first number indicates the interval in inches between the birds that each inspector examines. The second number indicates how many of the birds presented, the inspector is to inspect, i.e., “1” means inspect every bird. “4” means inspect every fourth bird, etc.

[47 FR 23435, May 28, 1982, as amended at 66 FR 22905, May 7, 2001]

§ 381.68 Maximum inspection rates—  
New turkey inspection system.

(a) The maximum inspection rates for one inspector New Turkey Inspection (NTI-1) and two inspector New Turkey Inspection (NTI-2) are listed in the table below. These line speeds are

MAXIMUM TURKEY INSPECTION RATES

| Inspection system | Line<br>configuration | Number of<br>inspectors | Birds/Minute |                              |            |                              |
|-------------------|-----------------------|-------------------------|--------------|------------------------------|------------|------------------------------|
|                   |                       |                         | J-Type       |                              | Bar-Type   |                              |
|                   |                       |                         | (<16#) light | (>16#) <sup>1</sup><br>heavy | (<#) light | (>16#) <sup>1</sup><br>heavy |
| NTI-1 .....       | 12–1                  | 1                       | 32           | 30                           | 25         | 21                           |
| NTI-2 .....       | <sup>2</sup> 24–2     | 2                       | 51           | 41                           | 45         | 35                           |

<sup>1</sup> This weight refers to the bird at the point of post-mortem inspection, without blood, feathers, or feet.

<sup>2</sup> The turkeys are suspended on the slaughter line at 12-inch intervals, with two inspectors each looking at alternating birds at 24-inch intervals.

[50 FR 37512, Sept. 16, 1985]

Subpart J—Ante Mortem  
Inspection

§ 381.70 Ante mortem inspection; when  
required; extent.

(a) An ante mortem inspection of poultry shall, where and to the extent considered necessary by the Administrator and under such instructions as he may issue from time to time, be made of poultry on the day of slaughter in any official establishment.

for lines using standard 9-inch shackles on 12-inch centers with birds hung on every shackle and opened with J-type or Bar-type opening cuts. Maximum rates for those establishments having varying configurations will be established by the Administrator but will not exceed those in the table. Neither the rates in the table nor those established for establishments with varying configurations shall be exceeded under any circumstances.

(b) There are two categories of turkeys for determining inspection rates, “light turkeys” and “heavy turkeys”. Light turkeys are all turkeys weighing less than 16 pounds. Heavy turkeys are all turkeys weighing 16 pounds or more. The weights refer to the bird at the point of post-mortem inspection, with blood, feathers and feet removed.

(c) The inspector in charge may reduce inspection line rates when in his/her judgment the prescribed inspection procedure cannot be adequately performed within the time available because the health conditions of a particular flock dictate a need for a more extended inspection.

(b) The examination and inspection of ratites will be on the day of slaughter, except:

(1) When it is necessary for humane reasons to slaughter an injured animal at night or on a Sunday or holiday, and the FSIS veterinary medical officer cannot be obtained; or

(2) In low volume establishments, when ante mortem inspection cannot be done on the day of slaughter, and the birds to be slaughtered have received ante mortem inspection in the

last 24 hours, provided the establishment has an identification and control system over birds that have received ante mortem inspection.

[37 FR 9706, May 16, 1972, as amended at 66 FR 22906, May 7, 2001]

**§ 381.71 Condemnation on ante mortem inspection.**

(a) Birds plainly showing on ante mortem inspection any disease or condition, that under §§ 381.80 to 381.93, inclusive, would cause condemnation of their carcasses on post mortem inspection, shall be condemned. Birds which on ante mortem inspection are condemned shall not be dressed, nor shall they be conveyed into any department of the official establishment where poultry products are prepared or held. Poultry which has been condemned on ante mortem inspection and has been killed or died otherwise shall under the supervision of an inspector of the Inspection Service, be disposed of as provided in § 381.95.

(b) Dead-on-arrival ratites and ratites condemned on ante mortem inspection will be tagged "U.S. Condemned" by an establishment employee under FSIS supervision and disposed of by one of the methods prescribed in § 381.95.

(c) All seriously crippled ratites and non-ambulatory ratites, commonly termed "downers," shall be identified as "U.S. Suspects."

(d) Ratites exhibiting signs of drug or chemical poisoning shall be withheld from slaughter.

(e) Ratites identified as "U.S. Suspects" or "U.S. Condemned" may be set aside for treatment. The "U.S. Suspect" or "U.S. Condemned" identification device will be removed by an establishment employee under FSIS supervision following treatment if the bird is found to be free of disease. Such a bird found to have recovered from the condition for which it was treated may be released for slaughter or for purposes other than slaughter, provided that in the latter instance permission is first obtained from the local, State, or Federal sanitary official having jurisdiction over movement of such birds.

(f) When it is necessary for humane reasons to slaughter an injured ratite at night or Sunday or a holiday, and

the Agency veterinary medical officer cannot be obtained, the carcass and all parts shall be kept for inspection, with the head and all viscera except the gastrointestinal tract held by the natural attachment. If all parts are not so kept for inspection, the carcass shall be condemned. If on inspection of a carcass slaughtered in the absence of an inspector, any lesion or other evidence is found indicating that the bird was sick or diseased, or affected with any other condition requiring condemnation of the animal on ante mortem inspection, or if there is lacking evidence of the condition that rendered emergency slaughter necessary, the carcass shall be condemned. Ratites that are sick, dying, or that have been treated with a drug or chemical and presented for slaughter before the required withdrawal period, are not covered by emergency slaughter provisions.

[37 FR 9706, May 16, 1972, as amended at 66 FR 22906, May 7, 2001; 67 FR 13258, Mar. 22, 2002]

**§ 381.72 Segregation of suspects on ante mortem inspection.**

(a) All birds, except ratites, that on ante mortem inspection do not plainly show, but are suspected of being affected with, any disease or condition that under §§ 381.80 to 381.93 of this Part may cause condemnation in whole or in part on post mortem inspection, shall be segregated from the other poultry and held for separate slaughter, evisceration, and post mortem inspection. The inspector shall be notified when such segregated lots are presented for post mortem inspection, and inspection of such birds shall be conducted separately. Such procedure for the correlation of ante mortem and post mortem findings by the inspector, as may be prescribed or approved by the Administrator, shall be carried out.

(b) All ratites showing symptoms of disease will be segregated, individually tagged as "U.S. Suspects" by establishment personnel under FSIS supervision with a serially numbered metal or plastic leg band or tag bearing the term "U.S. Suspect," and held for further examination by an FSIS veterinarian. Depending upon the findings of the veterinarian's examination, these birds